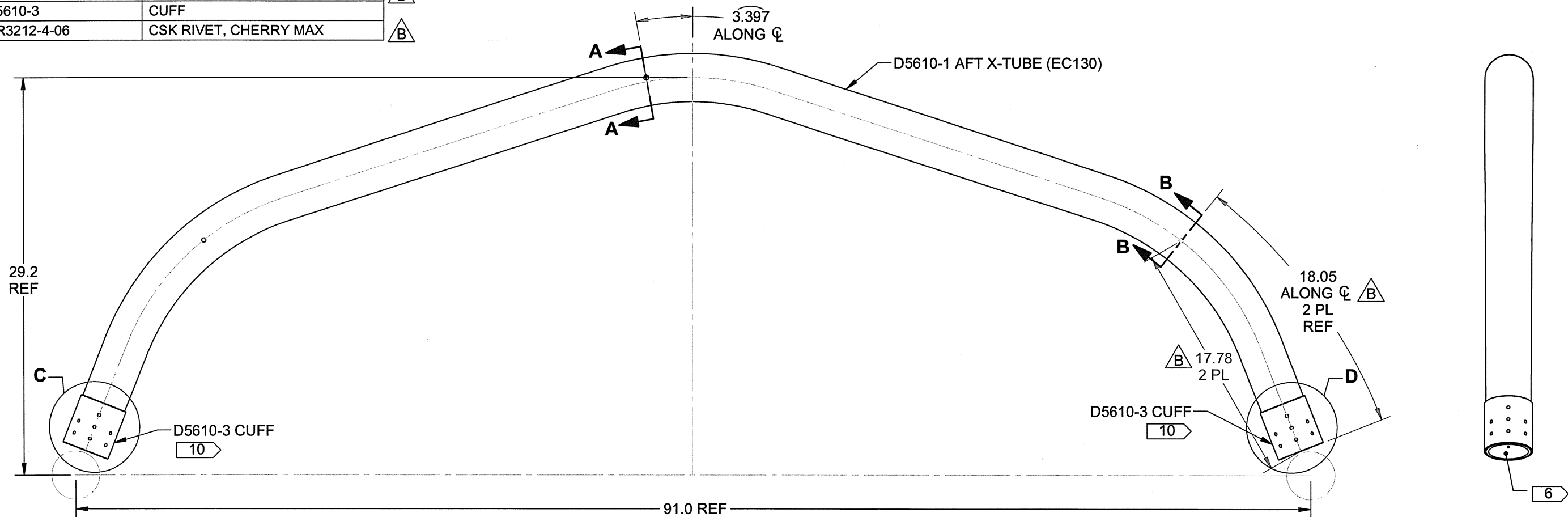
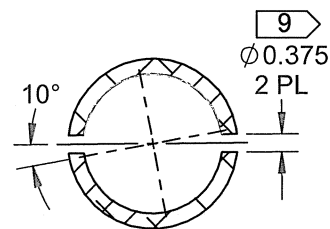


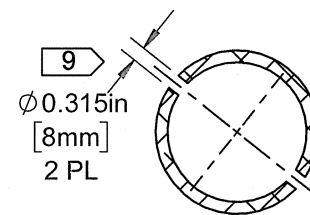
QTY -241	P/N	DESCRIPTION
X	D130-1048-241	AFT X-TUBE (EC130)
1	D5610-1	AFT X-TUBE (EC130)
2	D5610-3	CUFF
40	CR3212-4-06	CSK RIVET, CHERRY MAX



D130-1048-241 AFT X-TUBE (EC130)



SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X, 2 PL

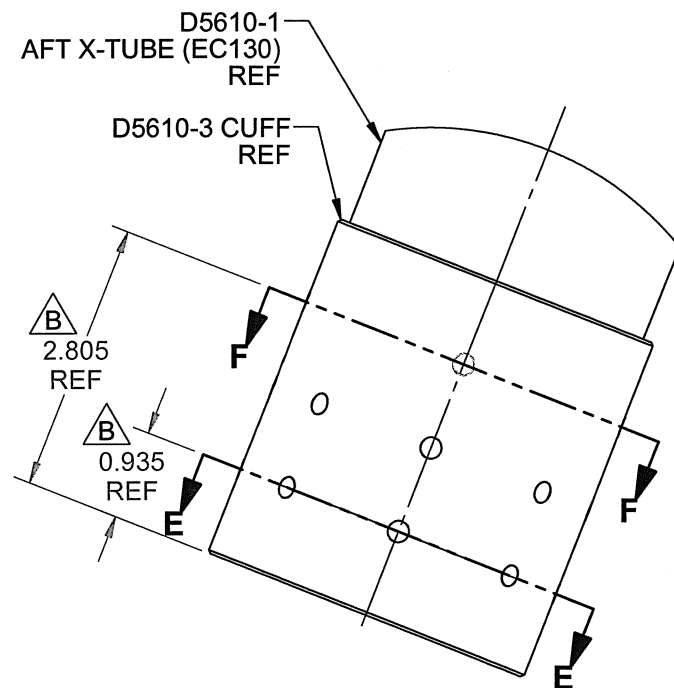
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE DART P/N "D130-1048-241" AND S/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON INSIDE OF CUFF
- 7) WEIGHT: 32.4 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE
- 9) MASK THESE HOLES PRIOR TO FINISH
- 10) ENSURE CUFF IS ALIGNED WITH ROW OF 3 HOLES ALONG TUBE CL, INSTALL CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT. APPLY A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT TO FAYING SURFACES BETWEEN CUFF AND CROSSTUBE. SEAL EDGES OF CUFFS TO ENSURE NO GAPS.
- 11) TRANSFER DRILL HOLES Ø0.129 FROM CUFF TO X-TUBE. TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.
- 12) WET INSTALL RIVETS WITH SEALANT.
- 13) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038, AFTER DRILLING BUT PRIOR TO INSTALLING CUFFS.

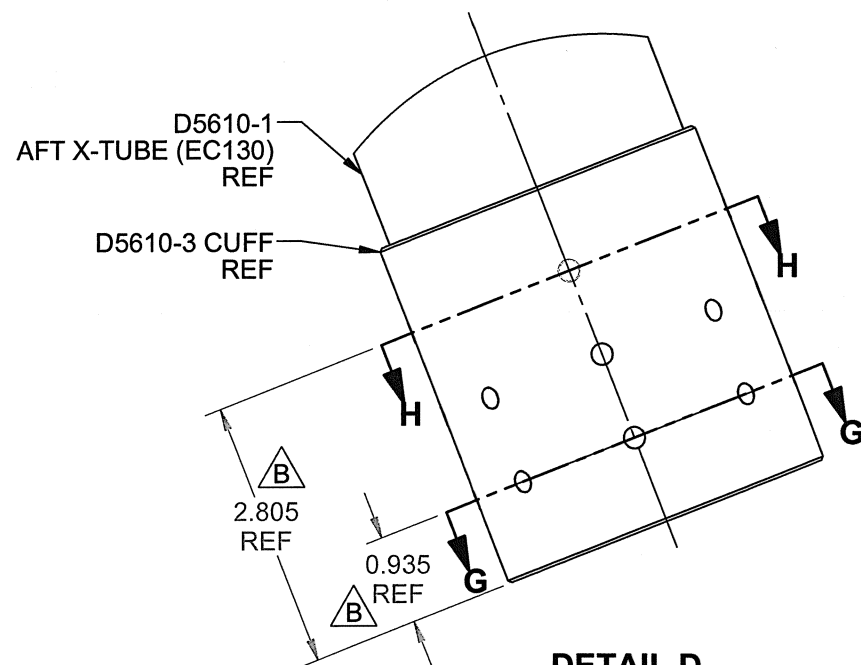
RELEASED

2019 FEB 25
ECN 19-567

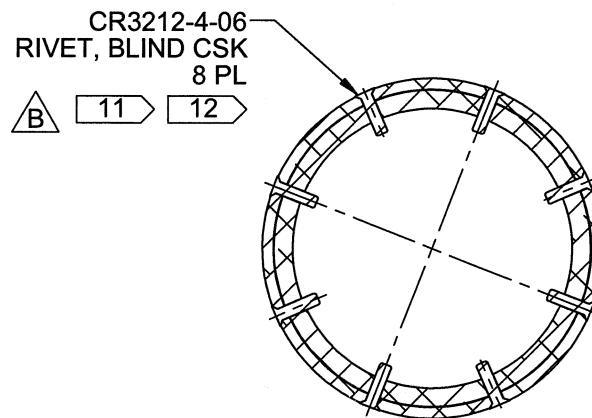
B	BENDING OPERATION MOVED TO D5610. REMOVED CUFF HOLE. GENERAL UPDATE FOR MANUFACTURING. ADDED PAINT AND SEALANT TO WEIGHT	ZF	19.02.05
A	NEW ISSUE	ZF	18.05.04
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. B
MFG. APPR.	DD	D130-1048-241	SHEET 1 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	AFT X-TUBE (EC130)	NTS
DATE	19.02.05	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



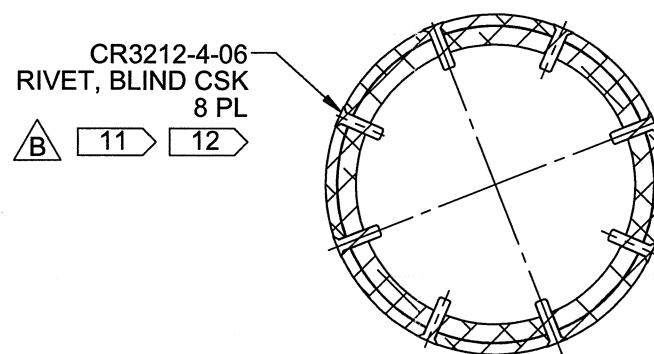
DETAIL C
SCALE 4X



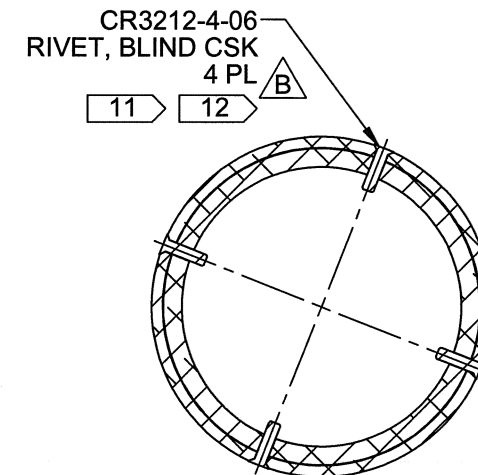
DETAIL D
SCALE 4X



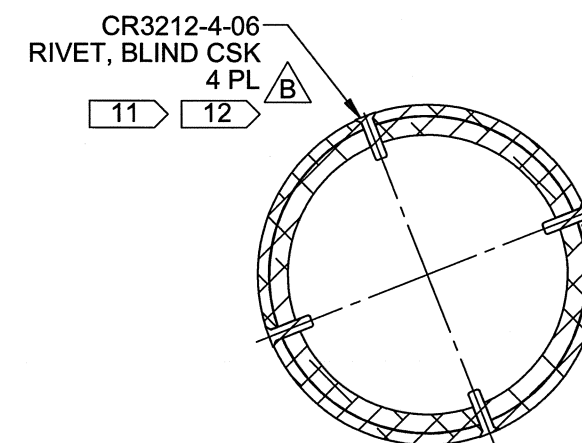
SECTION E-E
2 PL



SECTION G-G
2 PL



SECTION F-F



SECTION H-H

RELEASED

2019 FEB 25

APPROVED

DESIGN	NO	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. B
MFG. APPR.	DD	D130-1048-241	SHEET 2 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	AFT X-TUBE (EC130)	NTS
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